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33.97

DART AEROSPACE LTD	Work Order:	19529
Description: Bearpaw Kit (48" x 19") 205/430	Part Number:	K10015
Dwg: D2521 Rev. H	Qty:	5 Kits
Ref: K10015 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																								
1	DC	Issue Traveler Note: (1) K10015 Kit consists of Qty (2) D2521 Dwg not required	HJ	03.08.27	5																																								
2	DC	Photocopy bluefile: K10015 D205-564-011 D430-688-011 and create labels per PPP K10015 CHG002 (Bag Bluefiles separately) WK 36 HJ	HJ	03.09.04	5																																								
3	GA	Cut 2 blanks per (1) K10015 Kit Cut blank: 19.50" x 48.00" x 1.00" thick Material: Black UHMW 1" (MUHMWB10) M13307 Batch: M13578	VB	03.10.21	5																																								
4	MV	Inspect material for defects or damage prior to machining	ED	03/10/25	5																																								
5	MV	Machine as per Folio FA222 and Dwg D2521	ED	03/10/27	5																																								
6	QC2	Inspect parts as they come off the CNC machine	EP	03/10/27	5																																								
7	MV	Deburr	ED	03/10/27	5																																								
8	MV	Form as per Dwg D2521 using bending Jig DT8328	MX	03/11/05	5																																								
9	QC8 & 5	Second inspection	EL	03.11.08	5																																								
10	KP	Pick: Packing Kit (Note: D2521 is on the BOM as material from step 3) . <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>8</td><td>D2182B055</td><td>Rubber Cushion</td><td>09540-B18914</td></tr><tr><td>16</td><td>D2274</td><td>Radius Block</td><td>B19107</td></tr><tr><td>2</td><td>D2521</td><td>Bearpaw</td><td>B19529</td></tr><tr><td>16</td><td>D2529</td><td>Washer</td><td>B18930</td></tr><tr><td>8</td><td>D2947</td><td>Clamp</td><td>B19106</td></tr><tr><td>16</td><td>AN4-15A</td><td>Bolt</td><td>M13437</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>M13356</td></tr><tr><td>16</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M12620</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></table>	Qty	Part Number	Description	Batch	8	D2182B055	Rubber Cushion	09540-B18914	16	D2274	Radius Block	B19107	2	D2521	Bearpaw	B19529	16	D2529	Washer	B18930	8	D2947	Clamp	B19106	16	AN4-15A	Bolt	M13437	16	AN960JD416	Washer	M13356	16	MS21042L4	Nut (or -4)	M12620	1	Paperwork package from Step 2			Q	03-09-05	5
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			Q	03-11-10	5																																								
			Q	03-09-05	5																																								
11	QC4	Inspect Kit for 100% Completeness on the W/O	SB	03/11/11	5																																								
12	PK	Identify and pack for shipping as per PPP K10015 REV.C	Q	03-11-11	5																																								
13	AC	Cost / part 403.65	SYC	03-11-12	5																																								
14	DC	Close W/O 367.06 Inspect Level 21	HJ	03.11.13	5																																								

Rev	Date	Change	Revised By	Approved
A	01.10.16	K10015 created for Bearpaw Kit (MPP 2164)	SM	
B	03.05.26	Reformat; Incorporated D2521	KJ/RF	RF

BB 03-11-12 RF

RELEASED
03.07.01 RF

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 27, 2003
10:49 am

Work Order No : 0019529
Project Name : *K10015
Project For : WK338
Work Order Type : Main
Main WO Number :
House Part Number : *K10015
Description : Bearpaw Kit
Manufactured : Yes
Amount Req'd : 5
Amount Done : 0
Start Date : 08-27-03
Est Finish Date : 09-25-03
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Testing Hours :	0.00	0.00	0.00		
Testing Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
SubContract Hours :	0.00	0.00	0.00		
SubContract :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 19575
Description: Bear Paw Kit (48" x 19") 25/436		Part Number: K10015
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	± 0.010	0.747	✓		Vern	
0.375	± 0.010	0.384	✓		Vern	
35.000	± 0.010	35.000	✓		TAPE MEASURE	
6.188	± 0.010	6.193	✓		Vern	
44.500	± 0.010	44.500	✓		TAPE MEASURE	
4.125	± 0.010	4.115	✓		Vern	
2.437	± 0.010	2.445	✓		"	
1.563	± 0.010	1.573	✓		"	
1.000	± 0.010	1.010	✓		"	
5.600	± 0.010	5.595	✓		"	
0.260	± 0.010	0.260	✓		"	
0.93	± 0.030	0.923	✓		"	
6.625	± 0.010	6.630	✓		"	
4.000	± 0.010	3.995	✓		"	
0.250	± 0.010	0.252	✓		"	
0.750	± 0.010	0.740	✓		Vern	
0.375	± 0.010	0.362	✓		Vern	
19.000	± 0.010	19.000	✓		TAPE MEASURE	
0.950	± 0.010	0.950	✓		Vern	
0.375	± 0.010	0.3			Vern	
5.625	± 0.010	5.615	✓		Vern	

Measured by: ED	Audited by: EG	Prototype Approval: N/A
Date: 02/10/22	Date: 02/10/22	Date:

Rev	Date	Change	Revised by	Approved
D	03.09.22	Reformat	KJ/RF	